

Date: Tuesday, 01/04/2008 10:32:54 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 38267		
Estimate Number	: 12403		
P.O. Number	:	Part Number	: D3511041
This Issue	: 01/04/2008 S.O. No. :	Drawing Number	: D3511 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34446	Material	:
Written By	: <u>02.04.01</u>	Due Date	: 08/04/2008 Qty: <u>6</u> Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-05-04 JLM		
	: Est Rev:B New process 06-05-05 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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10



Comment: Qty.: 1.5572 sf(s)/Unit Total : 18.6858 sf(s)

304 SHEET .188" THICK

(M304S0188)

Batch: 104699

IB 8-4-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3511

Dwg Rev: AProg Rev: A

IB 8-4-2

2-Deburr if necessary

IB 8-4-2

Identify as D3511-1



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-4-2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/04/08 (16)

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Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38267

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s)

CUP

Batch: 334246-22 3 35670 = 76

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 08/04/02 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/02 (6)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M106762

08.04.03 6

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SA 08/04/04 (6)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/04

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/04 (6)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 100700

08-04-04 (6)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/08 (46)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 239

08/04/08 (46)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

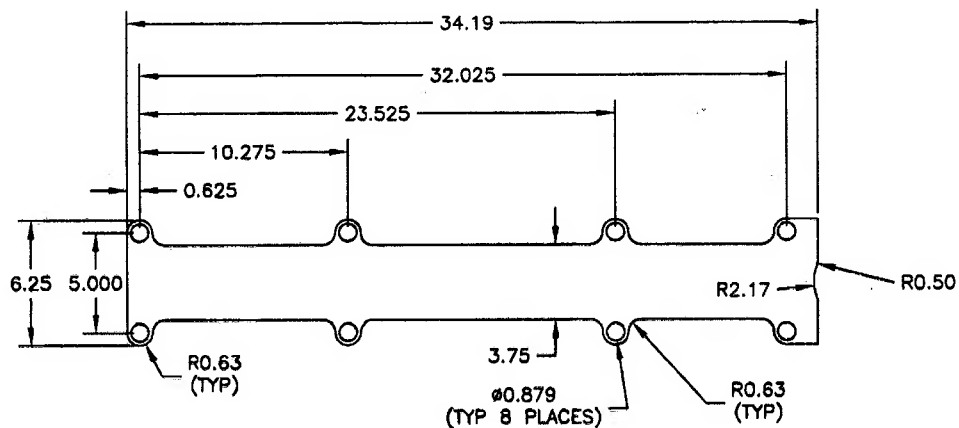
08/04/08 (46)

Job Completion



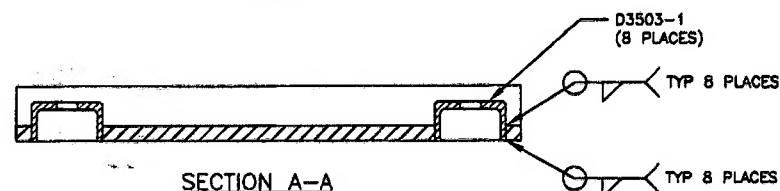
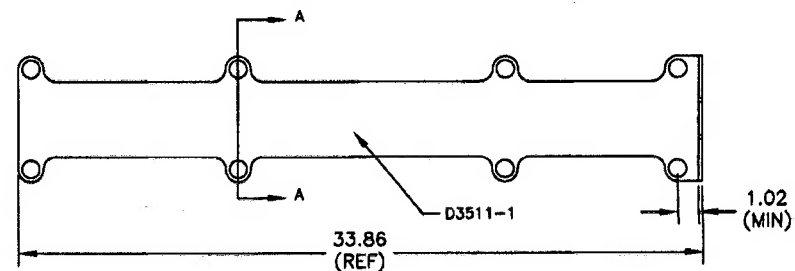
08/04/08

u/o 38267



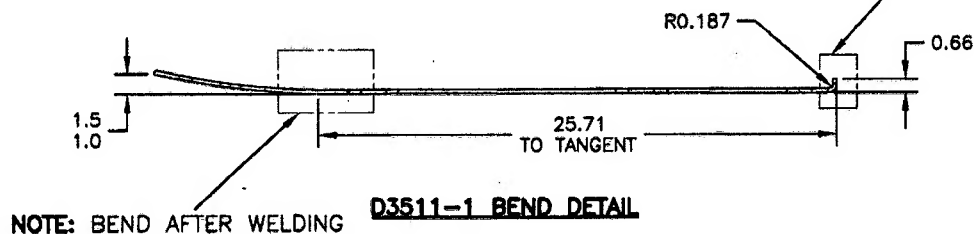
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



SECTION A-A

D3511-041 WELD DETAIL



NOTE: BEND AFTER WELDING

D3511-1 BEND DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

RELEASED

06.04.25 #

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A	06.04.04	NEW ISSUE
DESIGN	DRAWN BY PH	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3511
DATE	06.04.04	TITLE WEARPLATE
		SCALE NTS

REV. A
SHEET 1 OF 1